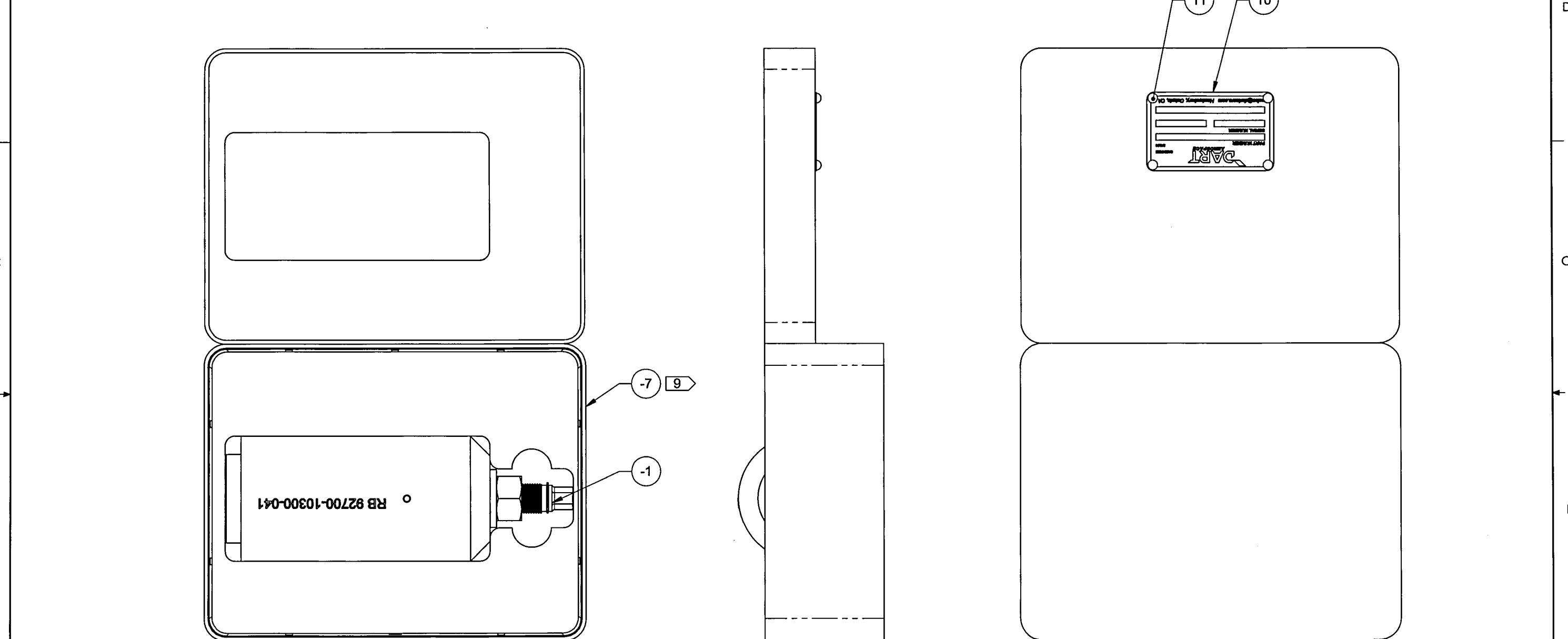


ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10300-041-1	SEAL INSTALLATION TOOL ASSY
-7	1	RB 92700-10300-041-7	PACKAGING ASSY
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 $X.XX = +/- 0.01" / +/- 0.5°$
 $X.XXX = +/- 0.005" / +/- 0.1°$
 $X.XXXX = +/- 0.0005" / +/- 0.05°$

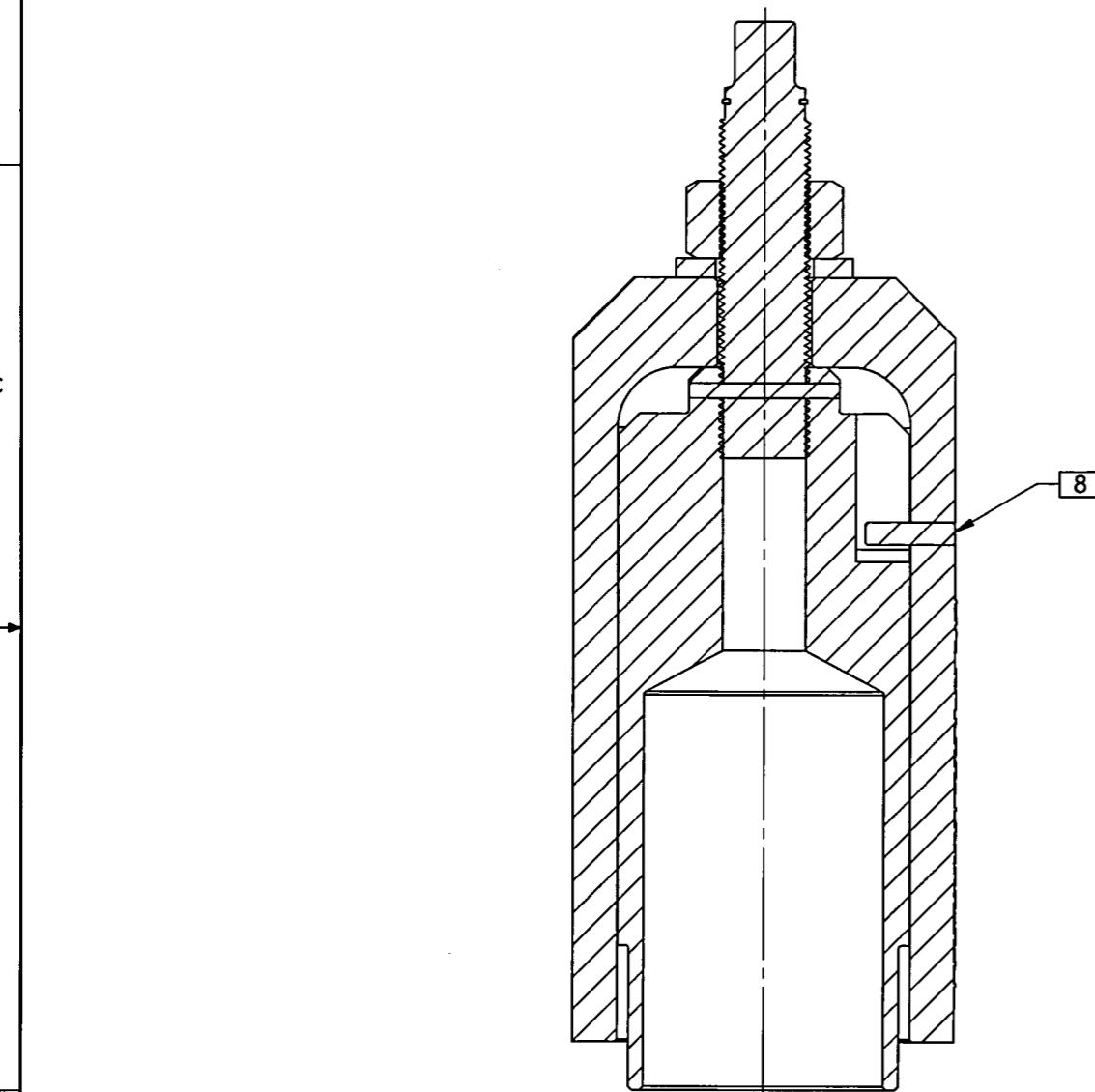
RB 92700-10300-041 SEAL INSTALLATION TOOL

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS
 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	18-609	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>M. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10300-041	SHEET 1 OF 10
APPROVED	<i>M. Lee</i>	TITLE	SCALE
		SEAL INSTALLATION TOOL	NTS
DATE	5/30/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10300-041-2	REACTOR ASSY
-4	1	RB 92700-10300-041-4	PULLER ASSY
12	1	McMaster#98410A126 OR EQUIV	EXTERNAL RETAINER RING
13	1	McMaster#94895A840 OR EQUIV	HEX NUT STEEL 3/4"-16 GRADE 8
14	1	McMaster#98023A036 OR EQUIV	FLAT WASHER STEEL FOR 3/4" SCREW

D



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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$$
 $X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$$
 $X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN, DOWEL PIN IN ITEM -2 MUST BE ALIGNED WITH THE SLOT OF ITEM -4 AS SHOWN
- 9) INSTALL ITEM 13 HAND TIGHT

8

7

6

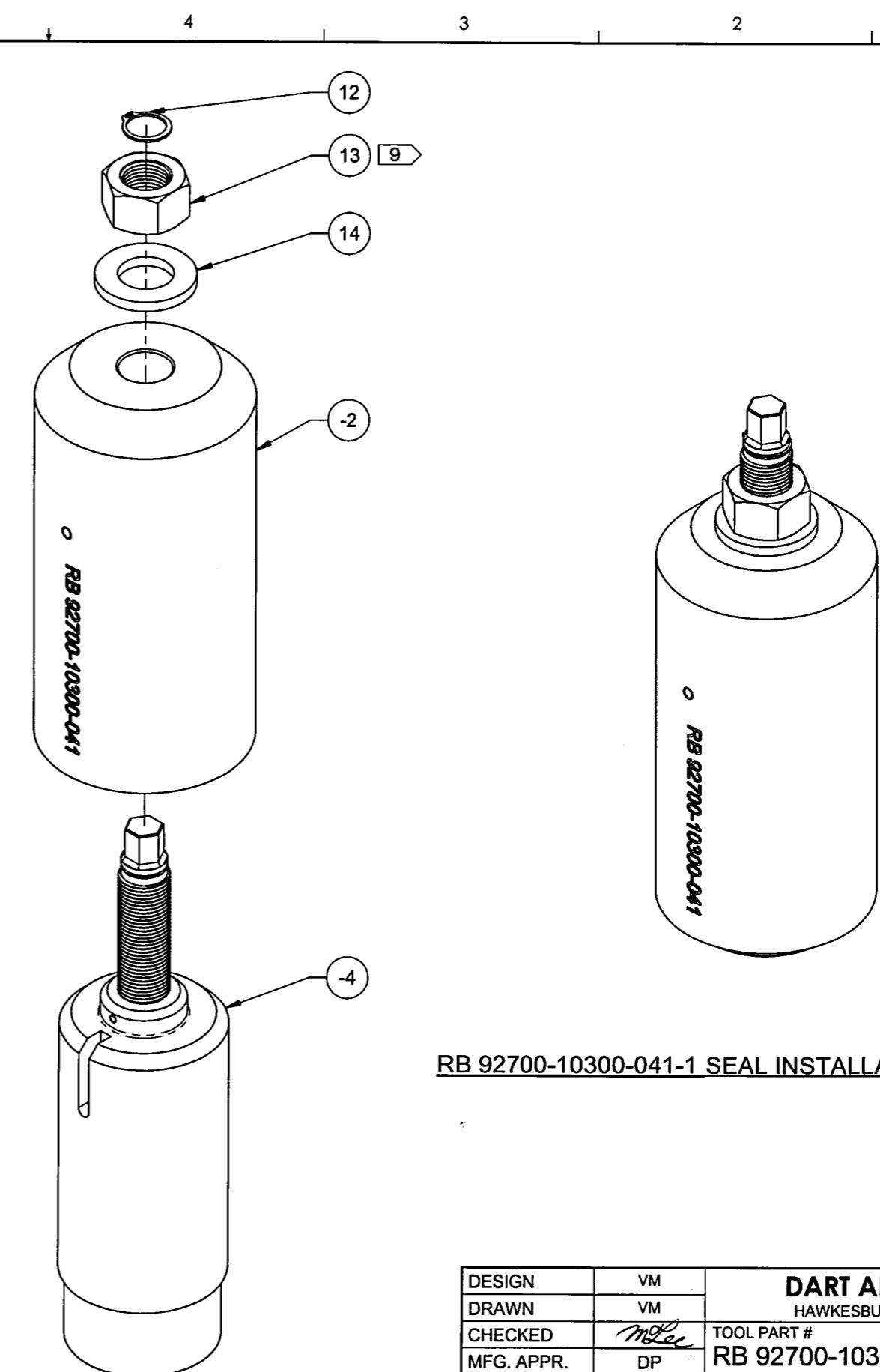
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3

2

1



RB 92700-10300-041-1 SEAL INSTALLATION TOOL ASSY

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>McLee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10300-041	SHEET 2 OF 10
APPROVED	<i>McLee</i>	TITLE	
		SCALE	
		NTS	
DATE 5/30/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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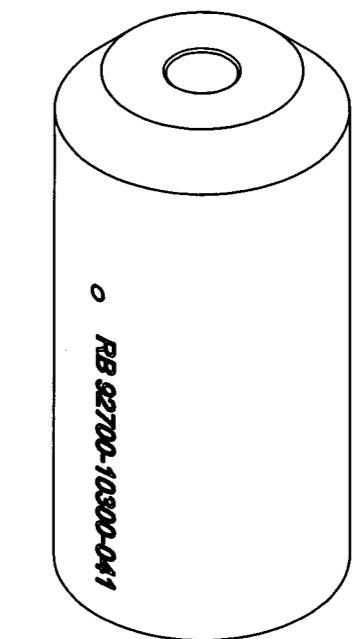
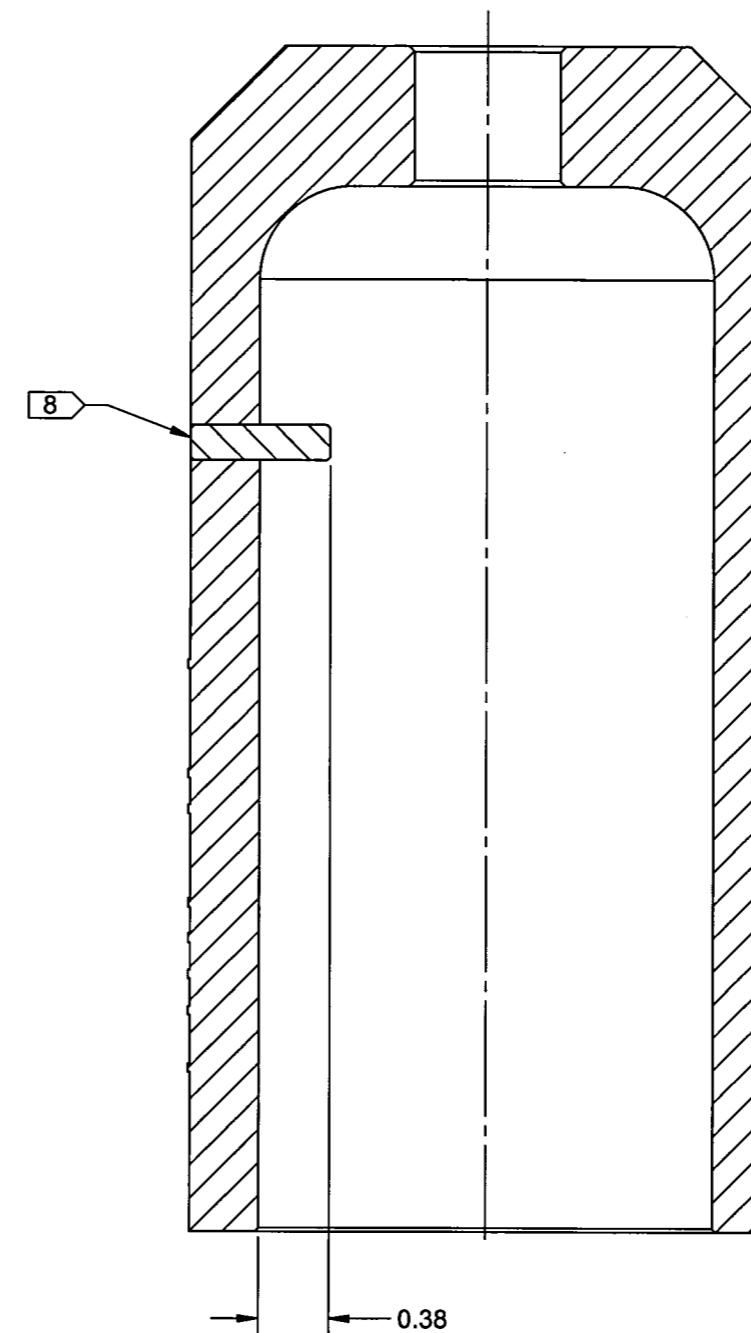
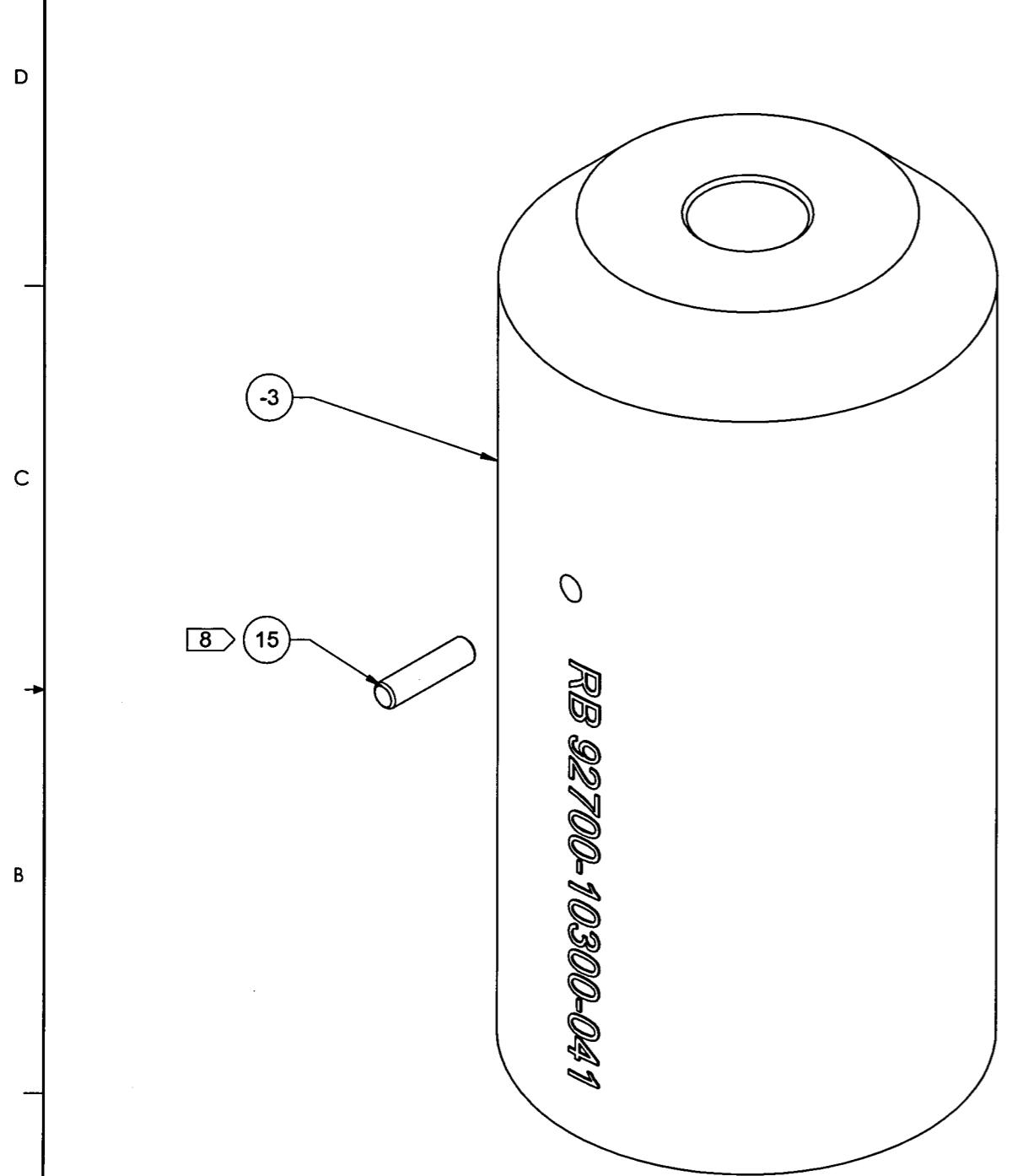
D

C

B

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ITEM #	QTY	PART #	PART TITLE
-3	1	RB 92700-10300-041-3	REACTOR
15	1	McMaster#98381A316 OR EQUIV	DOWEL PIN STEEL 3/16" DIA. x 3/4" LG.

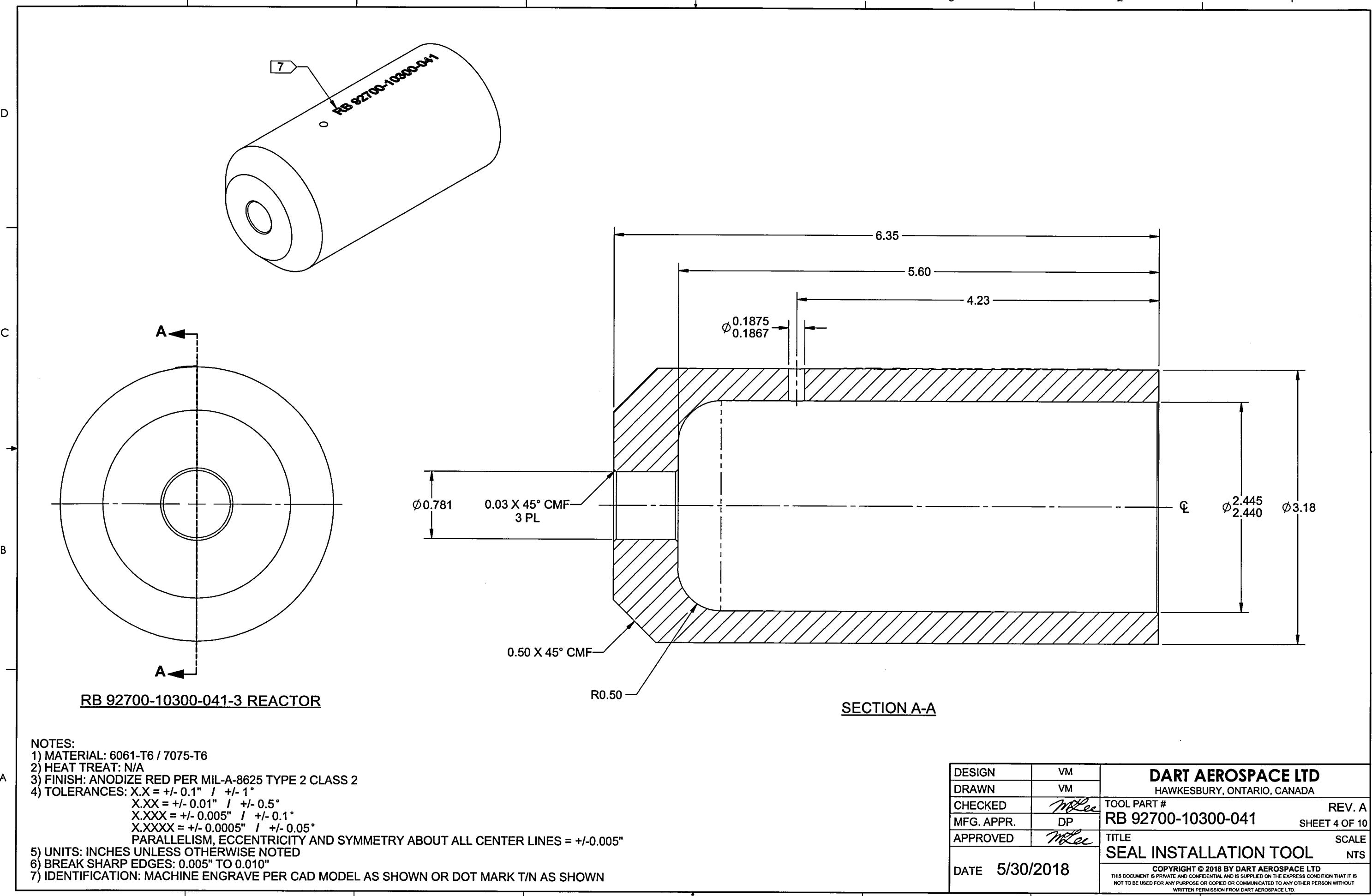


RB 92700-10300-041-2 REACTOR ASSY

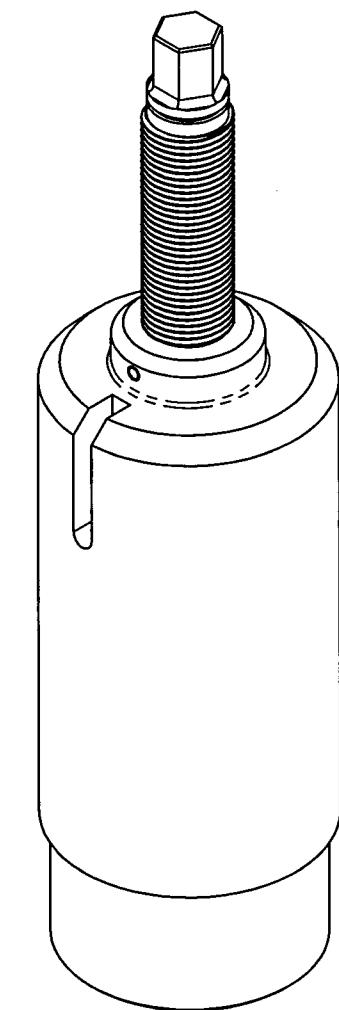
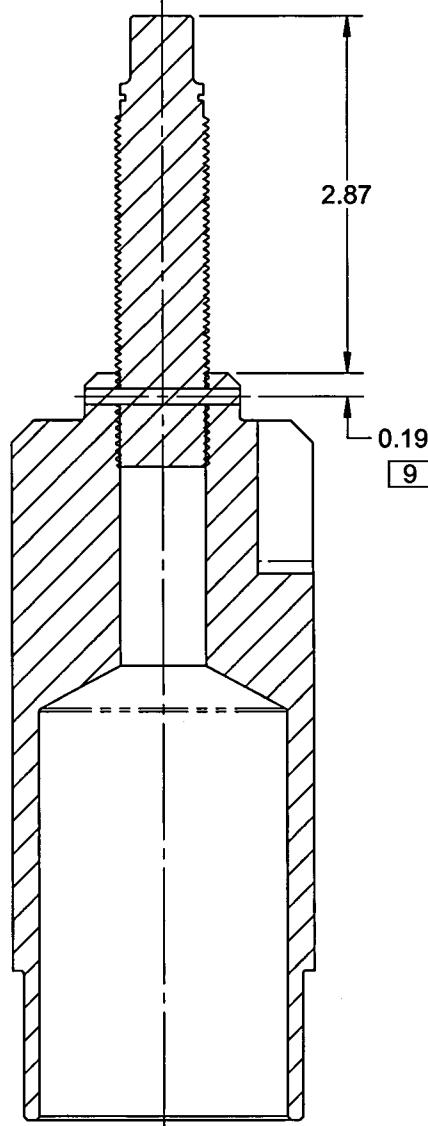
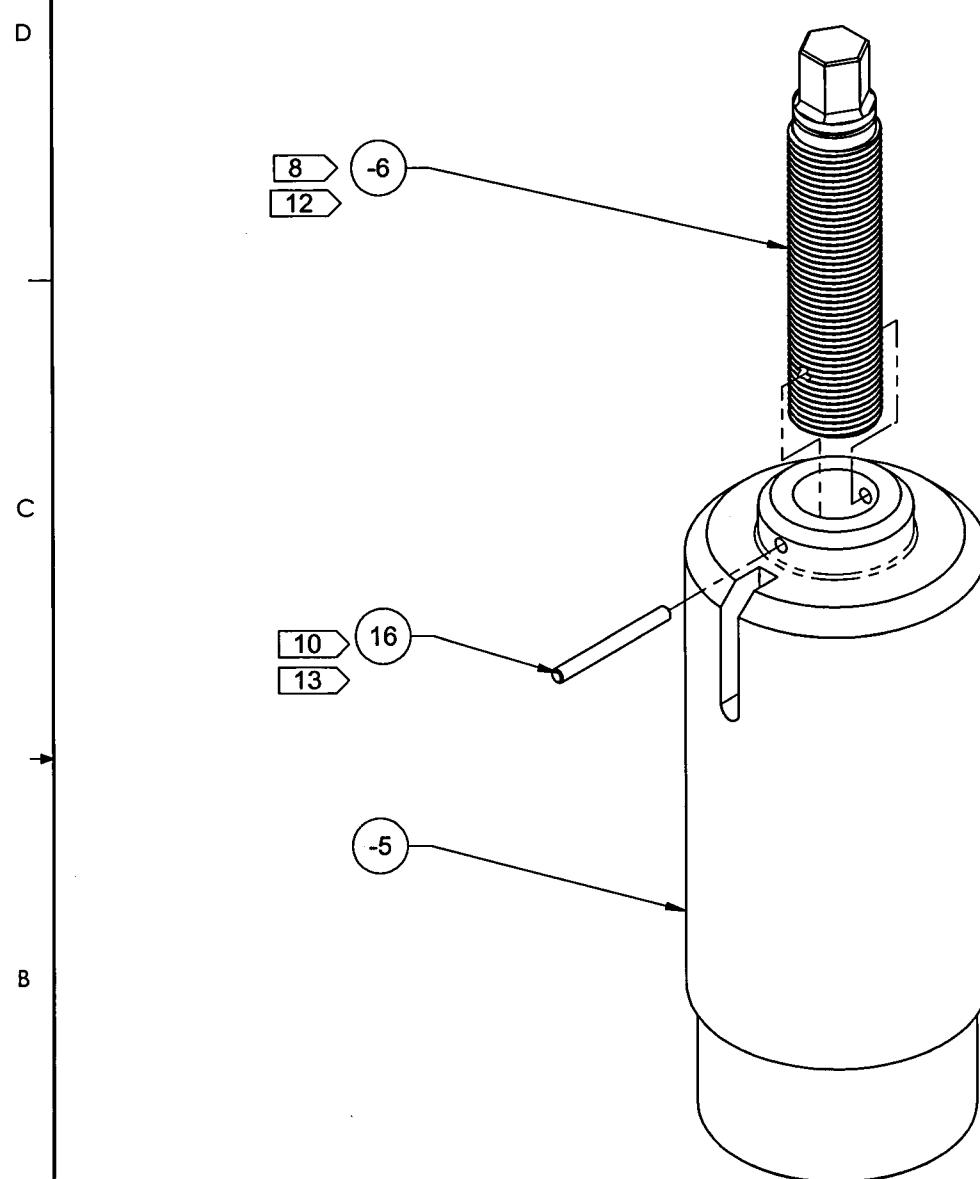
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$
 X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$
 X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 15 FLUSH TO THE OUTSIDE OF ITEM -3 AS SHOWN AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>McLee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10300-041	SHEET 3 OF 10
APPROVED	<i>McLee</i>	TITLE	SCALE
		SEAL INSTALLATION TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10300-041-5	PULLER
-6	1	RB 92700-10300-041-6	SCREW
16	1	McMaster#98380A477 OR EQUIV	SS DOWEL PIN 1/8" DIA. x 1-1/4" LG.



RB 92700-10300-041-4 PULLER ASSY

11

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) INSTALL ITEM -6 AS SHOWN

9) DRILL Ø0.1250/0.1242 HOLE THRU ALL

10) REMOVE ITEM -6 FROM ITEM -5 AND DEBURR HOLES

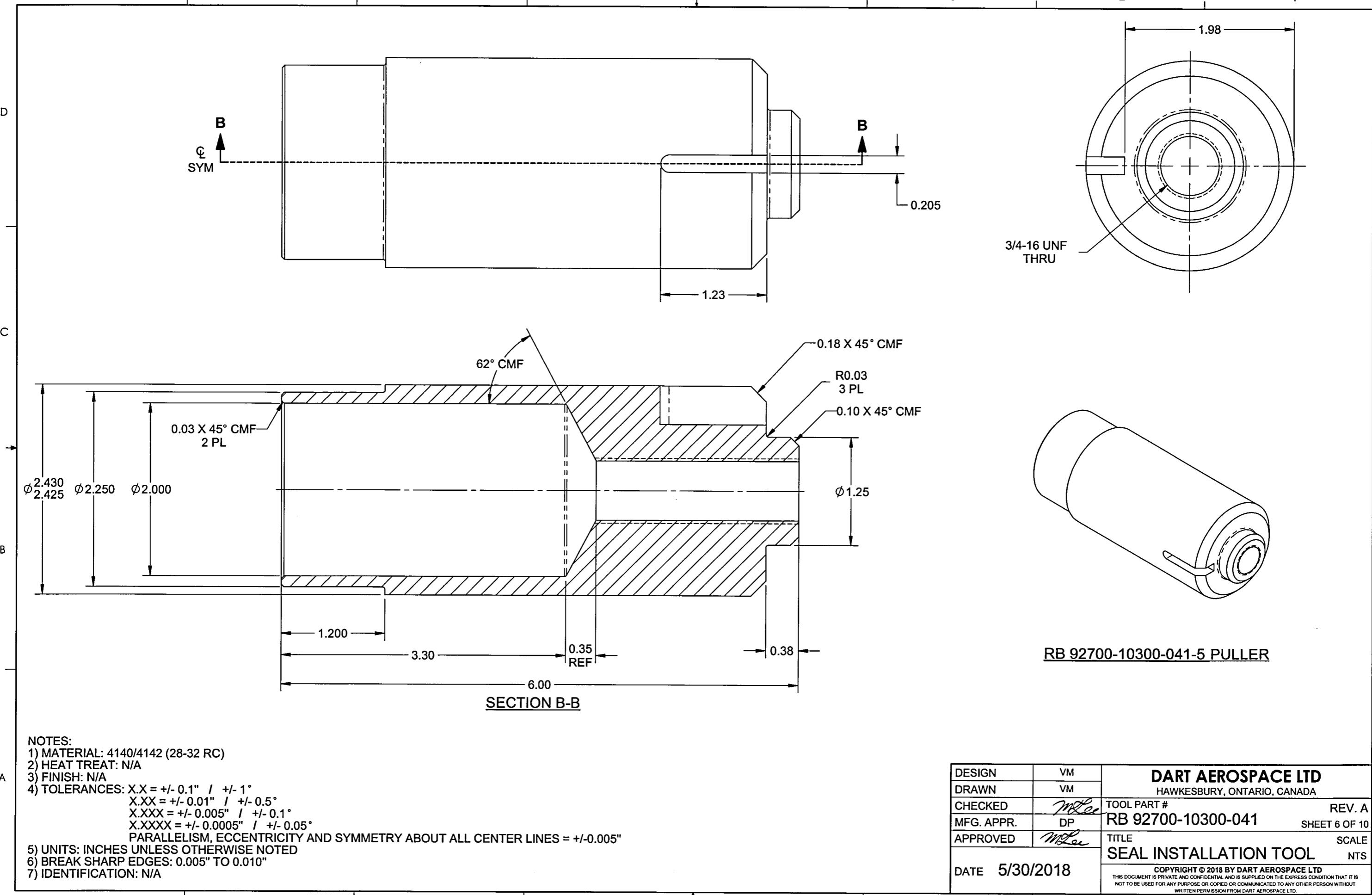
11) FINISH MUST BE APPLIED WHEN COMPONENTS ARE UNASSEMBLED

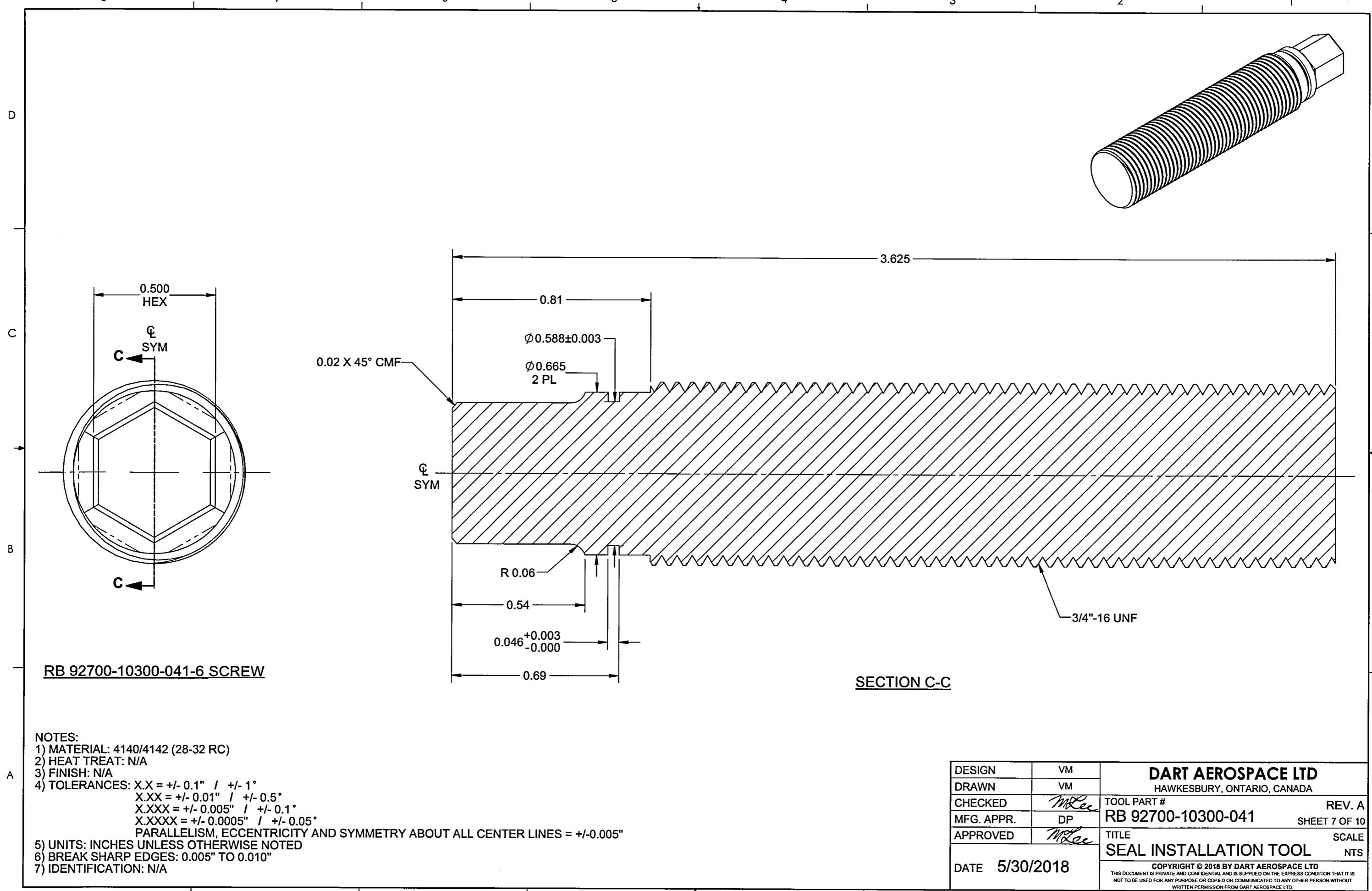
12) APPLY LOCTITE 262/263 TO MATING THREADS OF ITEM -6 THEN REINSTALL ITEM -6 INTO ITEM -5 UNTIL DOWEL PIN HOLE IS ALIGNED

13) APPLY LOCTITE 620 ONTO MATING SURFACES OF ITEM 16 AND ITEM -5 THEN PRESS FIT ITEM 16 INTO HOLE, UNTIL FLUSH WITH SURFACE

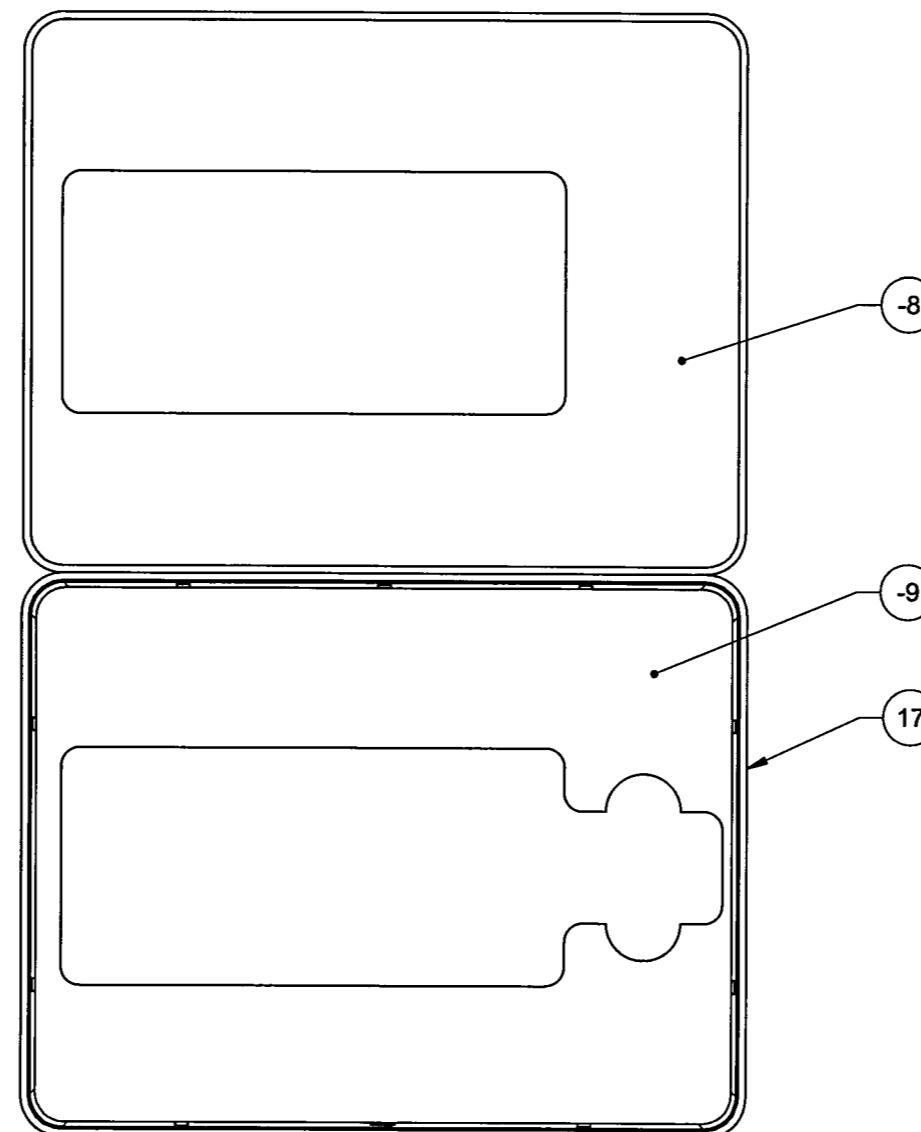
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MLee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10300-041	SHEET 5 OF 10
APPROVED	<i>MLee</i>	TITLE	
		SCALE	
		NTS	
DATE 5/30/2018		SEAL INSTALLATION TOOL	

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ITEM #	QTY	PART #	PART TITLE
-8	1	RB 92700-10300-041-8	TOP FOAM
-9	1	RB 92700-10300-041-9	BOTTOM FOAM
17	1	PELICAN #APP-1200-E	PELICAN CASE 1200



RB 92700-10300-041-7 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+- 0.1"$ / $+- 1^\circ$
 $X.XX = +- 0.01"$ / $+- 0.5^\circ$
 $X.XXX = +- 0.005"$ / $+- 0.1^\circ$
 $X.XXXX = +- 0.0005"$ / $+- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+-0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>MLee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10300-041	SHEET 8 OF 10
APPROVED	<i>MLee</i>	TITLE	
		SCALE	
		NTS	
DATE 5/30/2018		SEAL INSTALLATION TOOL	

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